

Work Order ID 74966

October 13, 2011 1:57:24 PM

74966

Page 1

Item ID: D4021-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 10/13/11 Start Qty: 64.00 ***64*** Cust Item ID:
 Required Date: 10/17/11 Req'd Qty: 64.00 ***64*** Customer:
 Reference:

Approvals: Process Plan: M.C. J Date: 11/10/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4021	B								

100

0.00

100

Hardinge

Hardinge CNC Lathe Small

Memo

0.00

TURN AS PER FOLIO FA 868 AND DWG D4021

DWG REV: _____

FOLIO REV: AA

***MACHINE TO .375" MAX OD ***

DEBURR

64 ✓ OK 11/10/17

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

64 ✓ OK 11/10/17

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

October 13, 2011 1:57:30 PM

Page 1

Work Order ID: 74966

74966

Parent Item: D4021-9

D4021-9

Parent Item Name: Bushing

Start Date: 10/13/11

Required Date: 10/17/11

Start Qty: 64.00

Required Qty: 64.00

Comments: IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD IPP
Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as
per dwg revB DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No				f	21.7600		5.312			
M304R0 375									**				
304 ROUND BAR 0.375													

OK / JH 11/10/17

Location

Loc Qty

Loc Code

MAT029

21.76

117130

2.46

118449

19.3

4.533

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74966
~~7752~~

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <i>SL/one</i>	Audited by: <i>SL</i>	Preliminary Approval:
Date: <i>11/10/17</i>	Date: <i>11-10-17</i>	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	

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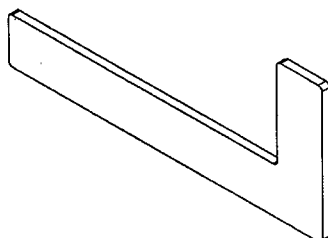
W/O:		WORK ORDER CHANGES					
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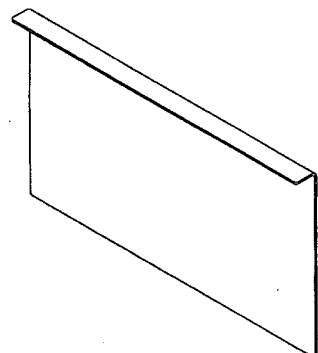
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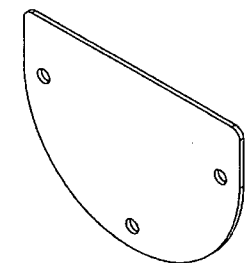
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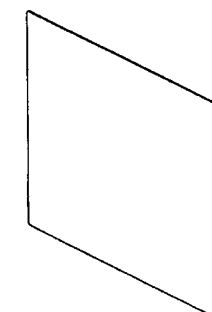
D4021-1 HANDLE PLATE



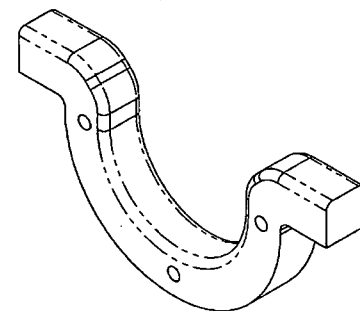
D4021-3 DATA PLATE



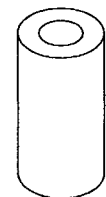
D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



D4021-9 BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74966 11/10/11 M.L.J

RELEASED
2010-04-14
WP

B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4021 REV. B SHEET 1 OF 3 TITLE MISC PARTS - 350 BASKET SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.04.06		

8 7 6 5 4 3 2 1

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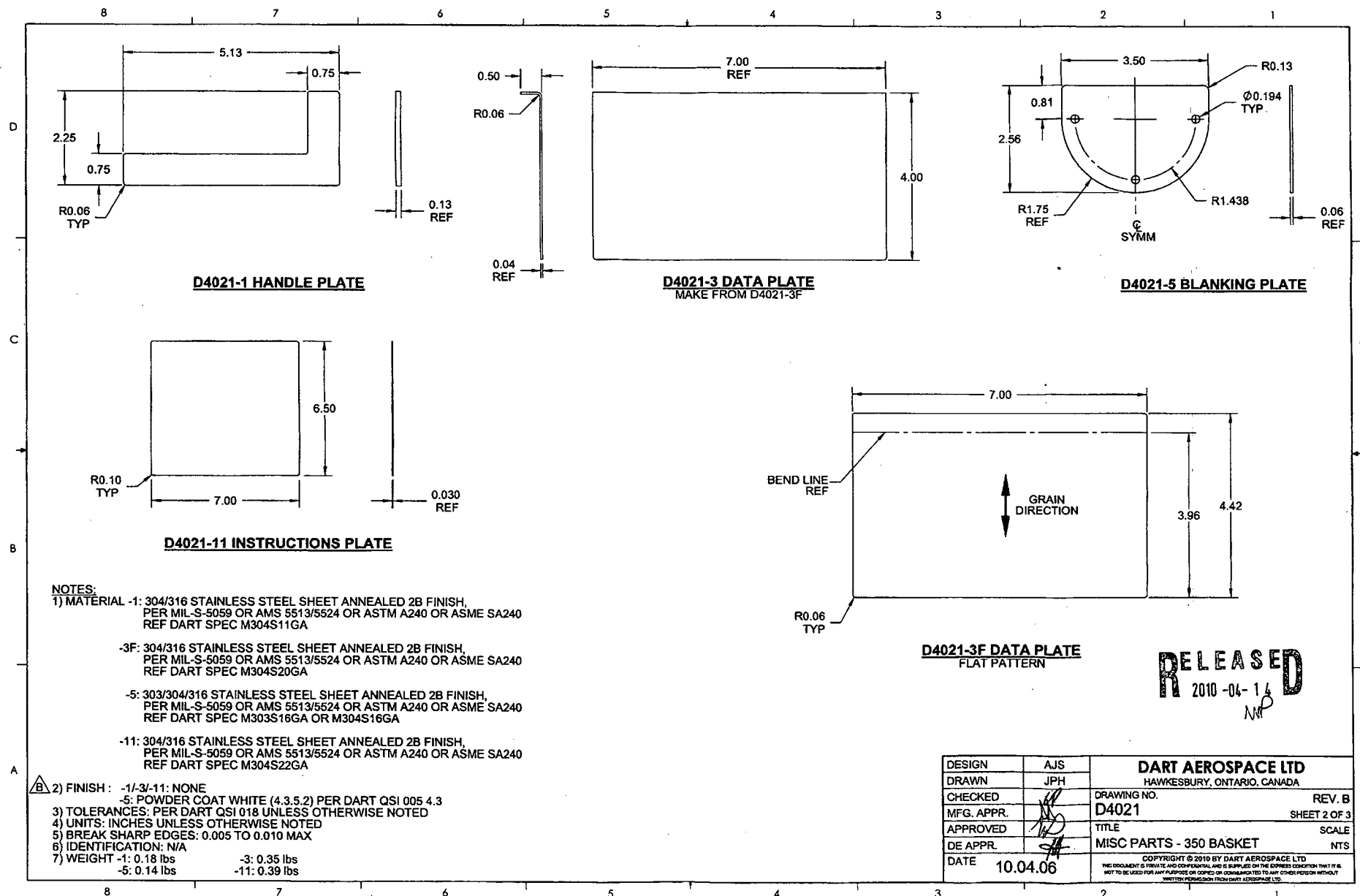
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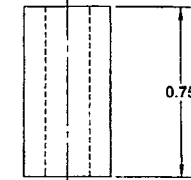
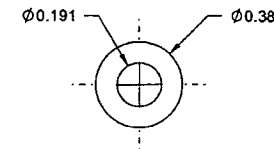
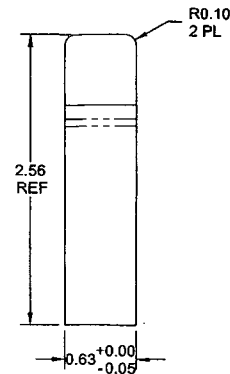
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A horizontal number line is shown, ranging from 0 to 8. The line is marked with vertical tick marks at every integer. The numbers 0, 1, 2, 3, 4, 5, 6, 7, and 8 are written above the tick marks. The segment between 0 and 1 is shaded gray.



D4021-7 HOOP

NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND UNAPPROVED FOR RELEASE. PERMISSION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPY OR REPRODUCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD.	

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